

AN: PAT 1986-274660
TI: Precision casting prods. mfr. by surface treatment using molten alkali and subsequent cleaning using acidic soln.
PN: **JP61199085-A**
PD: 03.09.1986
AB: The cleaning soln. is either aq. soln. contg. fluorine based surfactant having perfluoro alkyl group or acid-base soln., such as HCl, etc..; Complicated shapes and castings difficult to work, such as parts for gas turbines, automobiles, sewing machines, tools, magnetic steels, art crafts, dental uses, etc., are mfd.. In an example, protocol of bracket lug for bicycle flames was prep'd. with fusible wax and coated with slurry silica contg. foundry sand. The mould was hardened and the wax was removed. Pts. 100 pieces of casting were prep'd. and immersed in molten caustic soda at 550 deg.C for 45 min. and repeatedly cleaned using 30% conc. HCl soln. contg. 0.1% C8C17SO3H. All of the castings had good surface property.
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